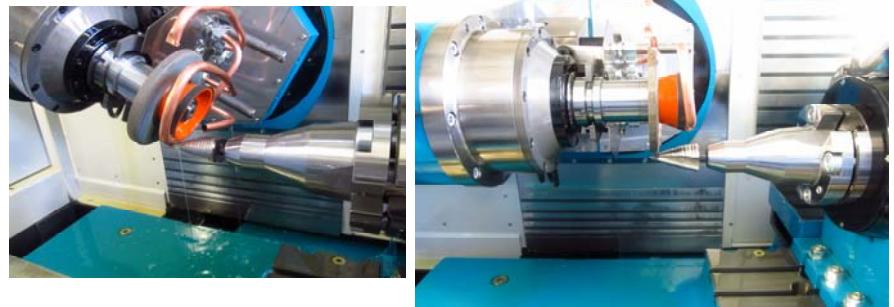


## Sheet Metal Stepdrill Ø6.7 - Ø35.3

A06-200

The pre-milled shear-flute of the sheet metal stepdrill is ground in 5 passes of each 0.3 mm increment plus 2 additional fast sparkout passes. The vitrified wheel for fluting has to be dressed after each 10 to 20 pieces. The O.D. is ground step by step in one pass (overmeasure around 0.1 to 0.3 mm).



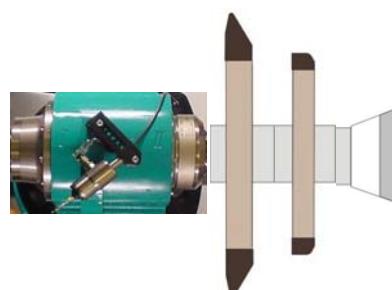
### 1. Cycletime for Production

Workpiece: Ø 6.7 - 35.3 mm, Z 2, Length 54 mm, Shear angle 12° Material HSS								
Operations	Probe	Flute 1	Gashing	End 2	End 1	O.D. Radial	Dress	Load
Feed [mm/Min]	2000	900	100	100	100	2000	150	9000
Power [kW]		8	2	1	1	2	2	1
Cutting speed [m/s]		40	32	32	32	45	32	
Used wheels		1	2	3	3	2	1	
Grinding time [s]	15	256	40	18	18	145	41	16
Total cycle time	9 Min 9							

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

### 2. Used Grinding Wheels

1	DXF Ø200 B20 C120
2	1A1-1V1 Ø125 B126
3	11V9 Ø75 B126



1 2 3

### 3. Machine and Software Requirements

Machines:	5 axes CNC grinders : GEMINI DMR	Coolant:	Synthetic Oil, pressure 16 bar
Control:	Fanuc 31i	Software:	Quinto 5
Accessories:	Dressing		
Responsible engineer:	OP. 3.5.12		

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J. SCHNEEBERGER Maschinen AG 4914 Roggwil Switzerland  
Subsidiaries in: France, Deutschland, Italia, United States, China